



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**RBW6405G02131-3G-PO**

**Job Sheet 191875**



**Part No:** RBW6405G02131-3G-PO

**Job Qty:** 2 pcs

**Part Name:** Tail Rotor Blade Damper Attachment Bushing Removal



**Part Weight:** 0 lbs

**Status:** New

**Priority:** Medium

**Job Created:** 3/11/19

**Job Tracking No:**

**Due Date:** 5/7/19

**Created By:** Patrick Lussier

**Type:** Stock

**Description:**

**Note:** DWG RBW6405G02131-3G Rev.D IPP Rev. A 18.10.22 New issue DP Verify DD

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                     | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier    |           | Sign-off    |
|-------|-------------------------------|-------|------------|----------|-----------|---------|------------------------|-----------|-------------|
|       |                               |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier  | Lead Time |             |
| 100   | Purchasing                    | 2 pcs | 5/7/19     | 5/7/19   | 0.00      | 0.00    | Purchasing - 1         |           | JUN 28 2019 |
|       |                               |       |            |          |           |         | Purchasing - 2         |           |             |
|       |                               |       |            |          |           |         | Purchasing - 3         |           |             |
| 110   | Packaging 2-1 - Receive - B4B | 2 pcs | 5/7/19     | 5/7/19   | 0.00      | 0.00    | Packaging 2 - 1 - B4B  |           | JUN 28 2019 |
|       |                               |       |            |          |           |         | Packaging 2 - 2 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 3 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 5 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 4 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 6 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 7 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 8 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 9 - B4B  |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 10 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 11 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 12 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 13 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 14 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 15 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 16 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 17 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 18 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 19 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 20 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 21 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 22 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 23 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 24 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 25 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 26 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 27 - B4B |           |             |
|       |                               |       |            |          |           |         | Packaging 2 - 28 - B4B |           |             |



**Container No:** S194776



**Part:** RBW6405G02131-3G

**Job No:** 191875

**Serial No/Batch:** S194776

**Revision:** 0

**Inspector:**

**Exp Date:**

**Instructions:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 06/28/19

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|                                 |       |        |           |  |                        |      |
|---------------------------------|-------|--------|-----------|--|------------------------|------|
|                                 |       |        |           |  | Packaging 2 - 29 - B4B |      |
|                                 |       |        |           |  | Packaging 2 - 30 - B4B |      |
|                                 |       |        |           |  | Packaging 2 - 31 - B4B |      |
|                                 |       |        |           |  | Packaging 2 - 32 - B4B |      |
|                                 |       |        |           |  | Packaging 2 - 33 - B4B |      |
|                                 |       |        |           |  | Packaging 2 - 34 - B4B |      |
|                                 |       |        |           |  | Packaging 2 - 35 - B4B |      |
|                                 |       |        |           |  | Packaging 2 - 36 - B4B |      |
| 120 QC 6                        | 2 pcs | 5/7/19 | 0.00 0.00 |  | QC 6 - 42              |      |
|                                 |       |        |           |  | QC 6 - 9               |      |
|                                 |       |        |           |  | QC 6 - 68              | DAS  |
|                                 |       |        |           |  | QC 6 - 61              | 61   |
| 130 Packaging 3-1 - Stock - B4B | 2 pcs | 5/7/19 | 0.00 0.00 |  | Packaging 3 - 1 - B4B  | 9-80 |
|                                 |       |        |           |  | Packaging 3 - 2 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 3 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 4 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 5 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 6 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 7 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 8 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 9 - B4B  |      |
|                                 |       |        |           |  | Packaging 3 - 10 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 11 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 12 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 13 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 14 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 15 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 16 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 17 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 18 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 19 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 20 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 21 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 22 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 23 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 24 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 25 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 26 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 27 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 28 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 29 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 30 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 31 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 32 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 33 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 34 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 35 - B4B |      |
|                                 |       |        |           |  | Packaging 3 - 36 - B4B |      |
| 140 QC 21 - FG                  | 2 pcs | 5/7/19 | 0.00 0.00 |  | QC 21 - FG - 21        |      |
|                                 |       |        |           |  | QC 21 - FG - 70        |      |
|                                 |       |        |           |  | QC 21 - SA - 53        |      |

Part Op 100 - (Purchasing) Issue P/O: 048047 MANUFACTURE RBW6405G02131-3G AS PER DWG Supplier: METEC  
 Descriptions: Certificate of conformity is required  
 110 - (Receive & Inspect for Damage & Mat'l Certs)  
 120 - (QC6- All purchased or subcontracted products)  
 130 - (Identify as per dwg & Stock Location: \_\_\_\_\_)  
 140 - (QC21- Final Inspection - Work Order Release)

x2 Rhs March 11, 2019

| Job BOM           |                                                    |              |                |           |
|-------------------|----------------------------------------------------|--------------|----------------|-----------|
| Part / Item       | Component Name                                     | Quantity     | Operation      | Container |
| RBW6405G02131-3GP | Tail Rotor Blade Damper Attachment Bushing Removal | 2 pcs (1 ea) | 100-Purchasing | 5194774   |

| Job Allocations |                   |          |           |           |
|-----------------|-------------------|----------|-----------|-----------|
| Operation       | Component Part    | Required | Inventory | Allocated |
| 100-Purchasing  | RBW6405G02131-3GP | 2        | 1         | 0         |

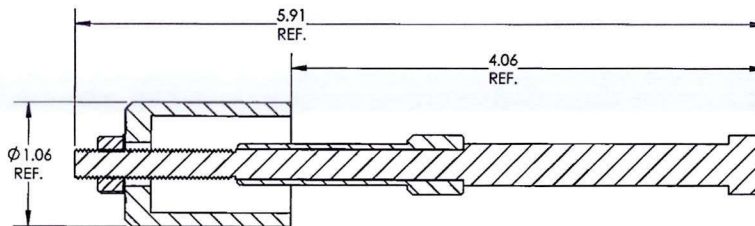
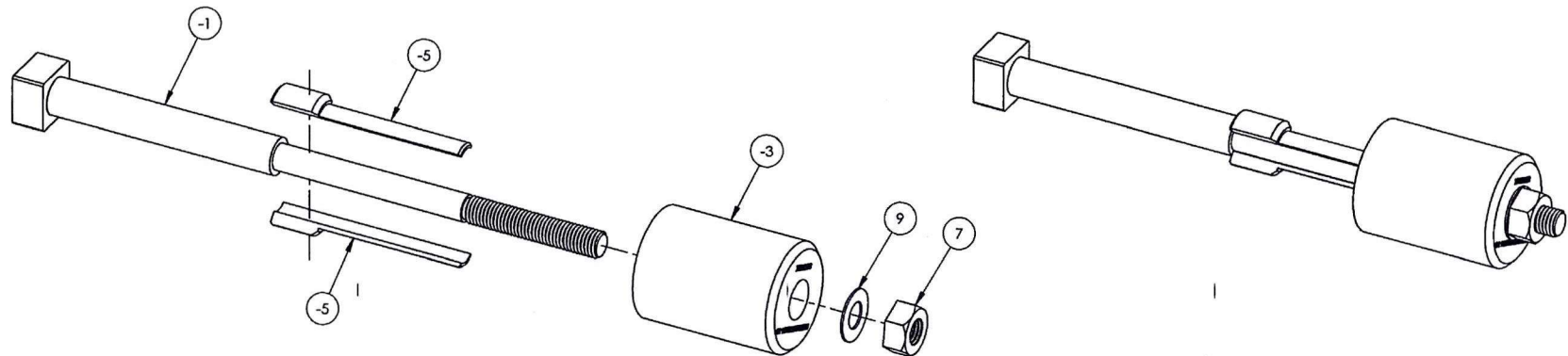
| Part Specifications                |  |  |  |  |
|------------------------------------|--|--|--|--|
| Specifications could not be found. |  |  |  |  |

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| ITEM # | QTY | PART #             | TITLE                       | PG | REV. | DESCRIPTION                                                                                                                                                                                                                                                                                                                                                                                                                            | ECN #   | DATE       | BY  | APPROVED |
|--------|-----|--------------------|-----------------------------|----|------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------|------------|-----|----------|
| -1     | 1   | RBW6405G02131-3G-1 | BOLT                        | 2  | 1    | CH'D TITLEBLOCK WAS RED BARN IS DART. -1 CH'D DIM WAS 4X.03 X 45° IS 4X R.34. -5 ADDED DIM (.338), CH'D DIM WAS 1.430 IS 1.45.                                                                                                                                                                                                                                                                                                         | 14-0205 | 10/31/2014 | DJN | JAG      |
| -3     | 1   | RBW6405G02131-3G-3 | BELL                        | 3  | 2    | -1 AND -5 CH'D MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -5 ADDED PART MARK FOR PAIRS NOTE.                                                                                                                                                                                                                                                                                                                               | 15-0294 | 9/10/2015  | RJC | JAG      |
| -5     | 2   | RBW6405G02131-3G-5 | QUARTER BELL                | 4  | 3    | -1 CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. -3 DELETED DIMS (.220), (2X .118). CH'D DIM WAS 1.12 IS 1.20. -5 CH'D MAT'L WAS 4140 Q&T/4142 Q&T IS 4140/4142. ADDED HEAT TREAT RC 28-34. CH'D FINISH WAS CAD PLATE YELLOW QQ-P-416 TYPE II CLASS II IS ZINC PLATE ASTM B633 TYPE I SC2. DELETED DIM 42°. | 17-0161 | 6/23/2017  | DPD | JAG      |
| 9      | 1   | McMaster#94191A150 | HEX NUT 1/4"-28 UNF GRADE 8 | -  | D    | -1 & -5 MATERIAL 4140-4142 CHANGED FOR 4140-4142 Q&T Rc ADDED, TEMPLATE UPDATED                                                                                                                                                                                                                                                                                                                                                        | 17-717  | 17.10.19   | VM  | WM       |
|        |     | McMaster#95229A420 | FLAT WASHER 1/4"            | -  |      |                                                                                                                                                                                                                                                                                                                                                                                                                                        |         |            |     |          |



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) REF AGUSTA T/N: 3G6405G02131

RBW6405G02131-3G TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL

|                                                                                                                                                                                                                                                                          |                                                        |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------|
| <b>DART AEROSPACE</b><br>Hawkesbury, Ontario, Canada                                                                                                                                                                                                                     |                                                        |
| TITLE<br>TAIL ROTOR BLADE DAMPER ATTACHMENT BUSHING REMOVAL                                                                                                                                                                                                              |                                                        |
| DWG NO.<br>RBW6405G02131-3G                                                                                                                                                                                                                                              | REV<br>D                                               |
| DESIGN BY: VM 10/19/2017                                                                                                                                                                                                                                                 | XXX ± .005 FRACTIONS ± 1/8                             |
| DRAWN BY: VM 10/30/2017                                                                                                                                                                                                                                                  | XX ± .01 ANGLES ± 5°                                   |
| CHECKED: SAG 10/30/2017                                                                                                                                                                                                                                                  | X ± .1 SURFACES ± 12°                                  |
| MFG. APPR: VM 10/31/2017                                                                                                                                                                                                                                                 | 1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED |
| APPROVED: VM 11/02/2017                                                                                                                                                                                                                                                  | 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009          |
| DATE: 10/30/2017                                                                                                                                                                                                                                                         | 3. DIMENSIONAL LIMITS APPLY AFTER PLATING              |
| SCALE: NTS                                                                                                                                                                                                                                                               | WEIGHT: N/A                                            |
| SHEET 1 OF 4                                                                                                                                                                                                                                                             |                                                        |
| COPYRIGHT © 2017 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |                                                        |



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## PO042847



**Supplier:** MEM001-VC  
Metec Metal Technology Inc.  
20 Terry Fox Drive PO Box 781  
Vankleek Hill  
ON  
K0B 1R0 Canada  
Phone: 613 678 3957  
Fax: 613 678 3956

**Attention:** Walz, Shigi

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**PO No:** PO042847

**PO Date:** 3/11/19

**Due Date:** ~~5/7/19~~ 5/21/2019

**Purchase Order  
Revision:**

**Revision Date:**

**Ship-To Contact:** Lussier, Patrick Phone:

**Via:** Ground

**Pymt Terms:** Net 60

**Freight Terms:**

**Special Comments:**

### Items

| Line Item | Job    | Part                | Supplier Part No | Item No | Description                                                | Status | Account | Due Date                       | Order Quantity | Received Quantity | Balance | Unit Price (CAD)    | Extended Price     |
|-----------|--------|---------------------|------------------|---------|------------------------------------------------------------|--------|---------|--------------------------------|----------------|-------------------|---------|---------------------|--------------------|
| 1         | 191873 | RBW6205G11532-3GP   |                  |         | Swashplate Support Stand As Per Dwg RBW6205G11532-3G REV 5 | Firmed | -       | 5/7/19<br>21                   | 2 pcs          | 0 pcs             | 2 pcs   | \$8,106.00/pcs      | \$16,212.00        |
| 2         | 191874 | RBW6405G00332-3GP   |                  |         | Tail Rotor Pitch Control Adjustment Tool REV 5             | Firmed | -       | 5/7/19<br>21                   | 1 pcs          | 0 pcs             | 1 pcs   | \$1,500.00/pcs      | \$1,500.00         |
| 3         | 191875 | RBW6405G02131-3GP   |                  |         | Tail Rotor Blade Damper Attachment Bushing Removal REV D   | Firmed | -       | 5/7/19<br>21                   | 2 pcs          | 0 pcs             | 2 pcs   | \$500.00/pcs        | \$1,000.00         |
| 4         | 191876 | RBW6305G26631-3G-1P |                  |         | Pin REV 2                                                  | Firmed | -       | <del>5/7/19</del><br>5/30/2019 | 8 Ea           | 0 Ea              | 8 Ea    | \$56.25/Ea          | \$450.00           |
| 5         | 191877 | RBW6305G26631-3G-3P |                  |         | Handle rev 2                                               | Firmed | -       | <del>5/7/19</del><br>5/30/2019 | 8 Ea           | 0 Ea              | 8 Ea    | \$56.25/Ea          | \$450.00           |
|           |        |                     |                  |         |                                                            |        |         |                                |                |                   |         | <b>Grand Total:</b> | <b>\$19,612.00</b> |





Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# PURCHASE ORDER

## PO042847



### Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

#### Procurement Quality Clauses

A005 RIGHT OF ENTRY  
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)  
A012 CHEMICAL AND PHYSICAL TEST REPORTS  
A016 PERSONNEL QUALIFICATION  
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)  
A026 CERTIFICATION OF MATERIAL CONFORMANCE  
A041 QUALITY MANAGEMENT SYSTEM  
A042 DART NOTIFICATION BY SUPPLIER  
A043 RETENTION OF QUALITY DOCUMENT  
  
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM  
  
A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "ph".

Plex 3/12/19 9:41 AM dart.Lussier.Patrick



**METAL TECHNOLOGY INC.**

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

### Packing List

**Bill** Dart Aerospace Ltd.  
**To:** 1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada

**Ship** Dart Aerospace Ltd.  
**To:** 1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Canada

**Shipment No:** 25526  
**Shipment Date:** 27-Jun-2019  
**Ship Via:** Pick up at METEC  
**Order Number:** 3606  
**Order Date:** 03/13/19

**Customer Code:** DART  
**Phone:** (613) 632-9577  
**PO Number:** PO042847 ✓  
**Terms:** Net 60 Days

| ----- Quantity ----- |             |                |            |                 |             |                                                                        |                 |                   |
|----------------------|-------------|----------------|------------|-----------------|-------------|------------------------------------------------------------------------|-----------------|-------------------|
| <u>Item</u>          | <u>Open</u> | <u>Shipped</u> | <u>B/O</u> | <u>Canceled</u> | <u>Unit</u> | <u>Description</u>                                                     | <u>Revision</u> | <u>Job Number</u> |
| 3                    | 2           | 2 ✓            | 0          | 0               | EA          | RBW6405G02131-3GP Tail Rotor Blade Damper Attachment Bushing Removal ✓ | D               | 3606-03           |

DAS  
61  
9-89

**RECEIVED**

JUN 28 2019

**DART AEROSPACE LTD.**

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By  
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

| Quantity | Part Number         | Part Name                                             | Dwg<br>Rev.# | P.O. Number |
|----------|---------------------|-------------------------------------------------------|--------------|-------------|
| 2 ✓      | RBW6405G02131-3GP ✓ | Tail Rotor Blade Damper<br>Attachment Bushing Removal | D            | 42847 ✓     |

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MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, June 27, 2019